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D412-705-013
Job Sheet 186561



Part No: D412-705-013

Job Qty: 1 ea

Part Name: Intake Plenum Access Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F SHEET 18 IPP Rev:A New Issue 07-09-09 JLM Verified By:EC IPP Rev:B ECN 1052 07-11-05
DD Verified by:EC IPP Rev:C ECN 12-670 12.11.07 DD Verified by:JLM

Ship Via:

6640

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 22 2018
110	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-4		NOV 22 2018
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC4		NOV 22 2018
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-2-89		NOV 22 2018
135	DC	1 pcs	11/30/18	11/30/18	0.00	0.00	DC		NOV 23 2018
140	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		NOV 23 2018

Part Op 130 - Identify and pack for shipping as per PPP D412-705-013 Location : FG027
Descriptions: 135 - Photocopy bluefile & type labels per PPP D412-705-013 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3245-041	Access Panel Assembly LH	1 Ea (1 ea)	90-Start up Operation	5105274
D3245-042	Access Panel Assembly RH	1 Ea (1 ea)	90-Start up Operation	5098065
D3245-043	Door Assembly	2 Ea (2 ea)	90-Start up Operation	5055641
D3245-11	Gasket 9.01	2 Ea (2 ea)	90-Start up Operation	5094816
D3245-13	Gasket 9.50	2 Ea (2 ea)	90-Start up Operation	5030644
D3245-9	Gasket 8.35	2 Ea (2 ea)	90-Start up Operation	5081637
MS20427M3-3	Rivet	16 Ea (16 ea)	90-Start up Operation	PM136741-4
MS21060-L3K	Nut Plate	8 Ea (8 ea)	90-Start up Operation	5113825

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3245-041	1	3	0
	D3245-042	1	4	0
	D3245-043	2	3	0
	D3245-11	2	8	0
	D3245-13	2	7	0
	D3245-9	2	6	0
	MS20427M3-3	16	1,072	0
	MS21060-L3K	8	132	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____			

Container No: S130752
 Part: D412-705-013
 Job No: 186561
 Serial No/Batch: S130752
 Revision: F
 Inspector:
 Exp Date:
 Instructions: TC STC SH04-25 Issue Date: 04/09/21, EASA STC

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Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Specifications could not be found.

Plex 11/19/18 8:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.

